

Date: Wednesday, 4/4/2007 9:14:04 AM  
User: Kim Johnston

Process Sheet

*Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI UTILITY BASKET
Job Number	: 31624		
Estimate Number	: 10854		
*P.O. Number	: N/A	Part Number	: D350721041
This Issue	: 4/4/2007 S.O. No. : N/A	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: N/A
Previous Run	: 31414	Material	: N/A
Written By	: <u>07.04.04</u>	Due Date	: 4/18/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>07.04.04</u>		
Comment	: Est Rev: D as per Rev B 05-11-21 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D350-721-041CHG001

CHG 002 04 07.04.05

07.04.04

2.0	31624A	BASKET LID ASSEMBLY
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Comment: Sub-Component BASKET LID ASSEMBLY

D3325-041 B 31624A

3.0	31624B	BASKET BASE ASSEMBLY
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Comment: Sub-Component BASKET BASE ASSEMBLY

D3324-041 B 31624B

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

5.0	D2022101	Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2022-101

Spacer

1530543

7/5/3059

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET

Job Number: 31624

Part Number: D350721041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D2332041	Lid Prop Assembly 6.69"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 D2332-041

prop arm

B 31105

7.0	D2530	Handle Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Weldment

Batch:

~~X B 31105~~

B 31106

8.0	D2535	Spring
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

2 D2535

Spring

B 28363

9.0	D2537	Bushing
-----	-------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

2 D2537

Bushing

B 31104

10.0	D2931	Bumper
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

2 D2931

Bumper

B 28139

11.0	D3320041	Webbing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 D3320-041

Webbing

B 31662

7/5/3030

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 31624

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D33511

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D3351-1

Label

1531564

13.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN3-16A

Bolt

1103691

14.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN4-7A

Bolt

1167449

15.0

AN420A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-20A

Bolt

116895

16.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 AN4-22A

Bolt

14100731

17.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN5-17A

Bolt

1102140

7/5/30 S9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: HELI UTILITY BASKET

Job Number: 31624

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD416

Washer

M103691

19.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD416L

Washer

M103962

20.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN960JD516

Washer

M103641

21.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN960JD8

Washer

M103585

22.0

AN960JD9

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

32 AN960JD9

Washer

M16495

23.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN970-4

Washer

M103344

7/5/30 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 31624

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description:

24.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 32.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

32 MS20600AD4W3 Rivet

M107519

102929

25.0

MS20600AD4W2

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 MS20600AD4W2 Rivet

M4747

26.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 MS21042L3

Nut (or -3)

M103691

27.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L4

Nut (or -4)

M102552

28.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L5

Nut (or -5)

M102536

7/5/30 59

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET

Job Number: 31624

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg IIN-D350-721 Attach Travelers:

Seal rivet Holes with Sika Flex before riveting

A/R 291 Sika Flex

Batch:

MI02497

Exp Date:

10/2007

MF 07-05-31

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/31

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

32.0

D22301

Mounting Lug



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

3 D2230-1

Lug

B30992

33.0

D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 D2230-3

Clamp

B30545

34.0

D2856400

Abrasion Strip



Comment: Qty.: 2.5200 f(s)/Unit Total: 2.5200 f(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 D2856-4007.20"

Abrasion Strip

B30822

7/5/30 SQ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET

Job Number: 31624

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D33381

Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D3338-1

Lug

1323797 X

36.0

D3350041

Strut Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D3350-041

Strut

1531663 X

37.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 AN4-12A

Bolt

1103947 X

38.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN4-13A

Bolt

1101149 X

39.0

AN414A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN4-14A

Bolt

1102473 X

7/5/30 SQ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/01

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 9:14:05 AM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET

Job Number: 31624

Part Number: D350721041

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

AN960JD416

Washer



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

Pick: Packing Kit

Qty Part Number

28 AN960JD416

Description Batch

Washer

M103691 X

41.0

MS21042L4

Nut



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part Number

18 MS21042L4

Description Batch

Nut (or -4)

\* 8 ✓ 10  
M19099 M102552 7/5/30 Sg

42.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

06705310  
88 8760531 1

43.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-721-041

Location:

PPP Rev:

06705310 Sg

44.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06706101 1

Job Completion



h 070601

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Wednesday, 4/4/2007 9:14:15 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASSEMBLY
Job Number	: 31624A		
Estimate Number	: 10853		
P.O. Number	: N/A	Part Number	: D3325041
This Issue	: 4/4/2007	Drawing Number	: D3325 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: B
Previous Run	: 31414A	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 4/18/2007
Checked & Approved By	: <u>[Signature]</u> 07.04.04	Qty:	1 Um: Each
Comment	: Est Rev: A 05.02.09 New issue KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D33281	Basket Hinge
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3328-1 Hinge Plate A32406

[Signature] 07/05/28

2.0	D33491	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3349-1 Spacer Bushing A23757

[Signature] 07/05/28

3.0	D33521	Label Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3352-1 Label Plate A28065

[Signature] 07/05/28

4.0	D33671	Mounting Bracket
-----	--------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

2 D3367-1 Mounting Bracket B31430

Batch

[Signature] 07/05/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 31624A

Part Number: D3325041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

M4130NTS0500W035

4130 Square tube .5 x .5



Comment: Qty.: 21.5687 f(s)/Unit Total : 21.5687 f(s)  
Material: 4130 Cond. N Square tube per MIL-T-6736,  
1/2" x 0.035" wall  
M4130N-TS0.500W.035)

07/05/28

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
1-Cut tubes as per Dwg D3325

Qty	Part Number	Description	Batch
2	D3325-1	EndTube	
3	D3325-3	Interior Tube	
2	D3325-5	Full Length Tube	

M17679

Identify parts appropriately

2-Remove all markings from material

3-Drill and Weld as per Dwg D3325 & QSI 004  
AVRN/AS steel Rod M102226

4-Deburr as required

07/05/29

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-05-29 ①

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-05-29 ①

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M103441 BR/a.m

07-05-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 07/06/01  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date: Wednesday, 4/4/2007 9:14:15 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 31624A

Part Number: D3325041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf. 07-05-31 (1)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

8/5 07/05/31 (1)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/01

Job Completion



h 07.06.01

**Dart Aerospace Ltd**

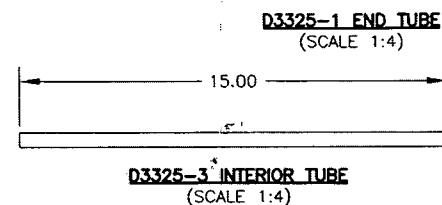
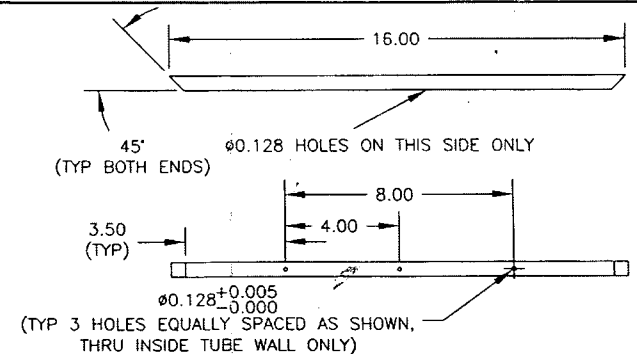
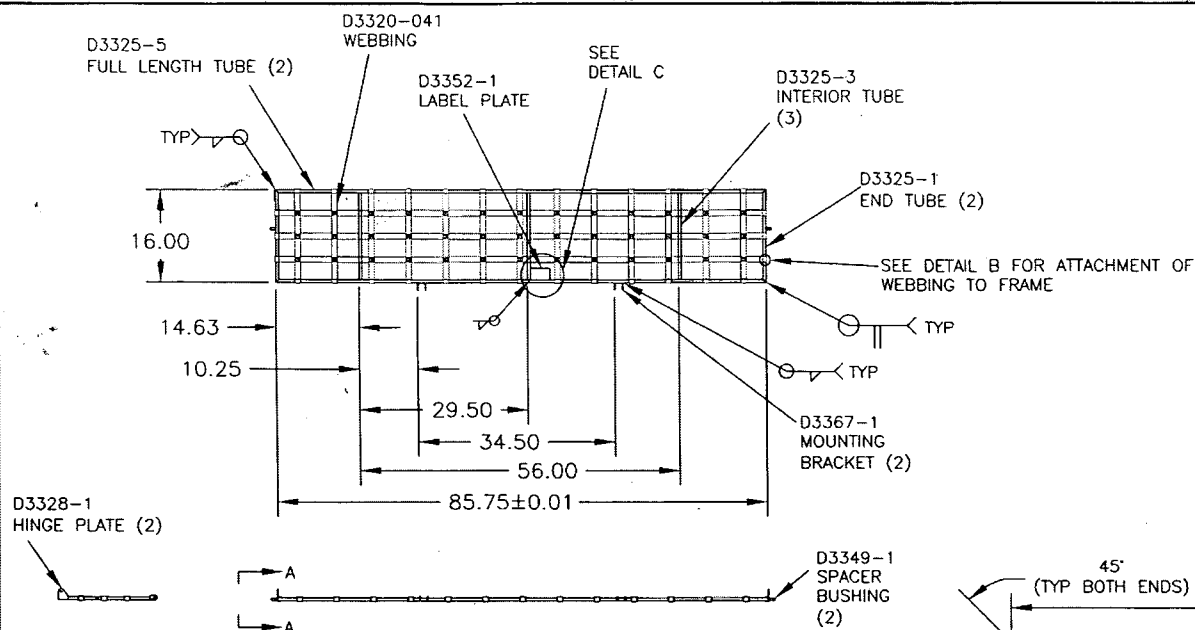
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



#### D3325-041 BASKET LID ASSEMBLY

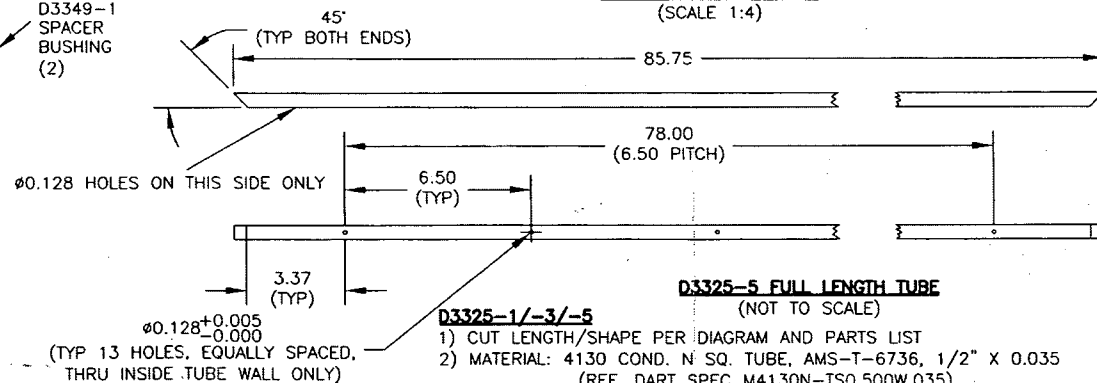
- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3 (PRIOR TO INSTALLATION OF D3320-041)
- 2) WELD PER DART QSI 004
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

#### PARTS LIST FOR D3325-041 BASKET LID ASSEMBLY

Part No.	Quantity	Description
D2729-1	1	PRODUCT ID LABEL
D3320-041	1	WEBBING
D3325-1	2	END TUBE
D3325-3	3	INTERIOR TUBE
D3325-5	2	FULL LENGTH TUBE
D3328-1	2	HINGE PLATE
D3349-1	2	SPACER BUSHING
D3351-1	1	PLACARD
D3352-1	1	LABEL PLATE
D3367-1	2	MOUNTING BRACKET
MS20600AD4W3	32	RIVET
AN960JD9	32	WASHER

RELEASED  
05-04-25

NO. 31624 A  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
SHOP COPY



#### D3325-1/-3/-5

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE, AMS-T-6736, 1/2" X 0.035 (REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

B	05.04.25	CHANGE RIVET AND HOLE DIAMETER
A	04.10.21	NEW ISSUE
DESIGN	DH	DART AEROSPACE LTD.
CHECKED	APPROVED	DART AEROSPACE LTD.
DATE	05.04.25	BASKET LID ASSEMBLY

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DRAWING NO.

D3325

TITLE

BASKET LID ASSEMBLY

REV. B

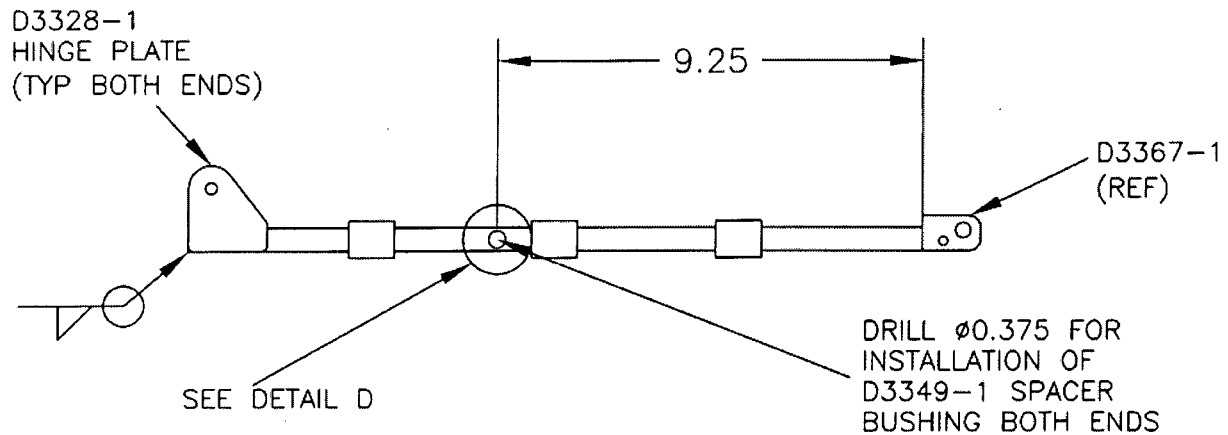
SHEET 1 OF 3

SCALE

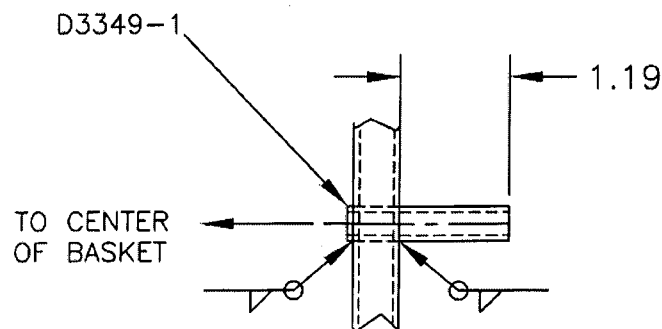
1:20



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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3325	REV. B SHEET 2 OF 3
DATE 05.04.25	TITLE BASKET LID ASSEMBLY		SCALE 1:4



VIEW A-A



DETAIL D  
(SCALE 1:2)

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WORK ORDER  
NO. 31624A

RELEASED  
05.04.28 [Signature]

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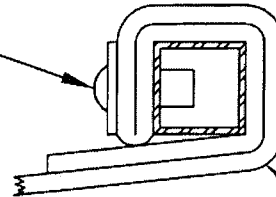
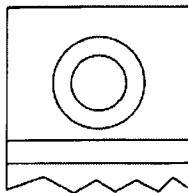
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3325	REV. B SHEET 3 OF 3
DATE 05.04.25	TITLE BASKET LID ASSEMBLY		SCALE 1:4

MS20600AD4W3 RIVET (1)  
AN960JD9 WASHER (1)

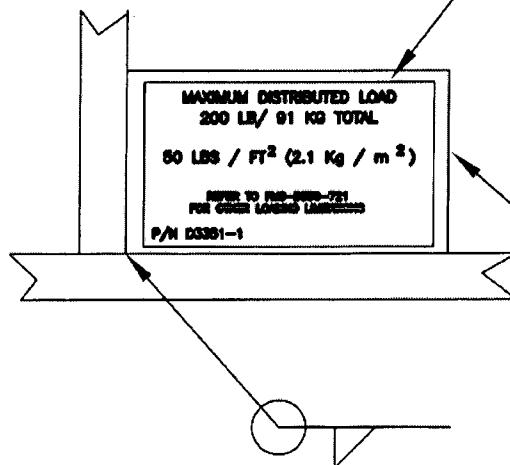


DETAIL B  
TYP. ATTACHMENT OF WEBBING TO LID  
FRAME  
(SCALE 1:1)

D3320-041 WEBBING

RELEASED  
05.04.28

ATTACH D3351-1 PLACARD  
ON TOPSIDE OF D3352-1



D3352-1

OUTBOARD  
SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

IDENTIFY WITH DART P/N 31624A  
D350-721-041 USING  
D2729-1 PRODUCT ID LABEL  
INSTALLED ON UNDERSIDE OF  
D3352-1

DETAIL C  
LABEL PLATE ATTACHMENT  
(SCALE 1:2)

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Date: Wednesday, 4/4/2007 9:14:26 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET BASE ASSEMBLY
Job Number : 31624B	
Estimate Number : 10852	
P.O. Number : <u>NIA</u>	Part Number : D3324041
This Issue : 4/4/2007 S.O. No. : <u>NIA</u>	Drawing Number : D3324 UNDER REVIEW <i>PH 07.04.04</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>NIA</u> Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 31414B	Material : <u>NIA</u>
Written By : <u>07.04.04</u>	Due Date : 4/18/2007 Qty: 1 Um: Each
Checked & Approved By : <u>07.04.04</u>	
Comment : Est Rev: A 05.02.09 New issue KJ/JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D33283	Basket Hinge
-----	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3328-3 Hinge Plate B3240707/05/28

2.0	D33481	Clevis
-----	--------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3348-1 Clevis B2810907/05/28

3.0	D33493	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3349-3 Spacer Bushing B2375807/05/28

4.0	D33671	Mounting Bracket
-----	--------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3367-1 Mounting Bracket B3143007/05/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 4/4/2007 9:14:26 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY

Job Number: 31624B

Part Number: D3324041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

M4130NTS0500W035

4130 Square tube .5 x .5



Comment: Qty.: 48.9300 f(s)/Unit Total: 48.9300 f(s)  
Material: 4130 Cond. N Square tube per MIL-T-6736,  
1/2" x 0.035" wall  
M4130N-TS0.500W.035)

07/05/28

6.0

M569EX05018F

569 Expanded Metal



Comment: Qty.: 28.0000 sf(s)/Unit Total: 28.0000 sf(s)

Pick:

Qty Part Number Description

Batch

28s M569EX0.50-18F 1/2"-18gauge(.040") carbon steel M104056

07/05/28

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
1-Cut tubes as per Dwg D3324

Qty	Part Number	Description	Batch
3	D3324-1	Bottom Tube	
4	D3324-3	Full Length Tube	
2	D3324-5	Top End Tube	
2	D3324-7	Bottom End Tube	
10	D3324-9	Vertical Tube	

Identify parts appropriately

M17679

07/05/29

2-Remove all markings from material & check for foreign objects

3-Drill and Weld as per Dwg D3324 & QSI 004 using DT8781 A & B  
A/RN/Steel Rod M102226

4-Deburr as required

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-05-29 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/06/01  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 9:14:26 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY

Job Number: 31624B

Part Number: D3324041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 07-05-29 (1)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR/a.m 07-05-29

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07-05-31 (1)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location GA

SB 02-105/31 (1)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/01 (1)

Job Completion



U 07-06-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

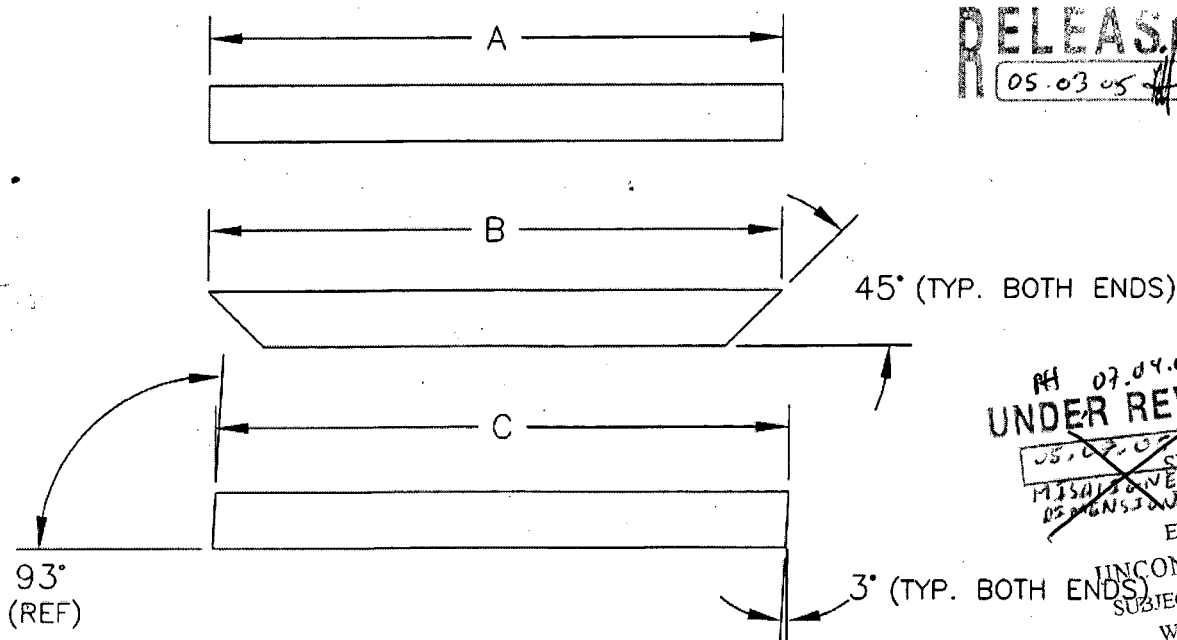
**NOTE:** Date & initial all entries



DESIGN FH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3324	REV. B SHEET 1 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE NTS
A	04.10.20	NEW ISSUE	
B	05.03.04	UPDATE MESH MATERIAL SPEC	

PARTS LIST FOR D3324-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3324-1	3	14.00	N/A	N/A	BOTTOM TUBE
D3324-3	4	N/A	86.50	N/A	FULL LENGTH TUBE
D3324-5	2	N/A	16.00	N/A	TOP END TUBE
D3324-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3324-9	10	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET



RELEASED  
05.03.05

PH 07.04.04  
UNDER REVIEW  
05.07.07  
MISAPPROVED  
05.08.07  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31624B

D3324-1/-3/-5/-7/-9

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 WALL  
(REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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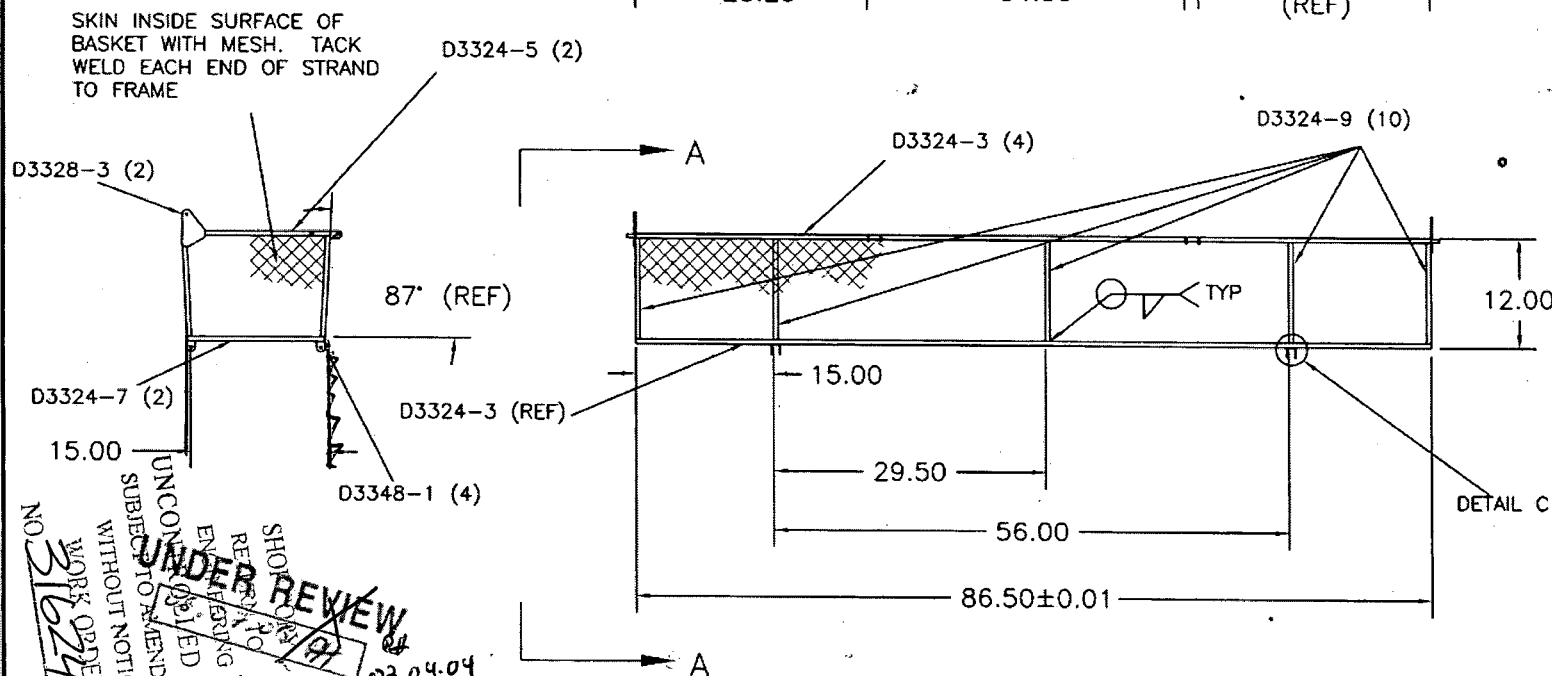


**DART**

DESIGN	PH	DRAWN BY	PH	<b>DART AEROSPACE LTD</b>	REV. B
CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA	
DATE	05.03.04	DRAWING NO.	D3324		SHEET 2 OF 3
		TITLE	BASKET BASE ASSEMBLY		SCALE 1:20

**RELEASED**  
05.03.05

SKIN INSIDE SURFACE OF BASKET WITH MESH. TACK WELD EACH END OF STRAND TO FRAME



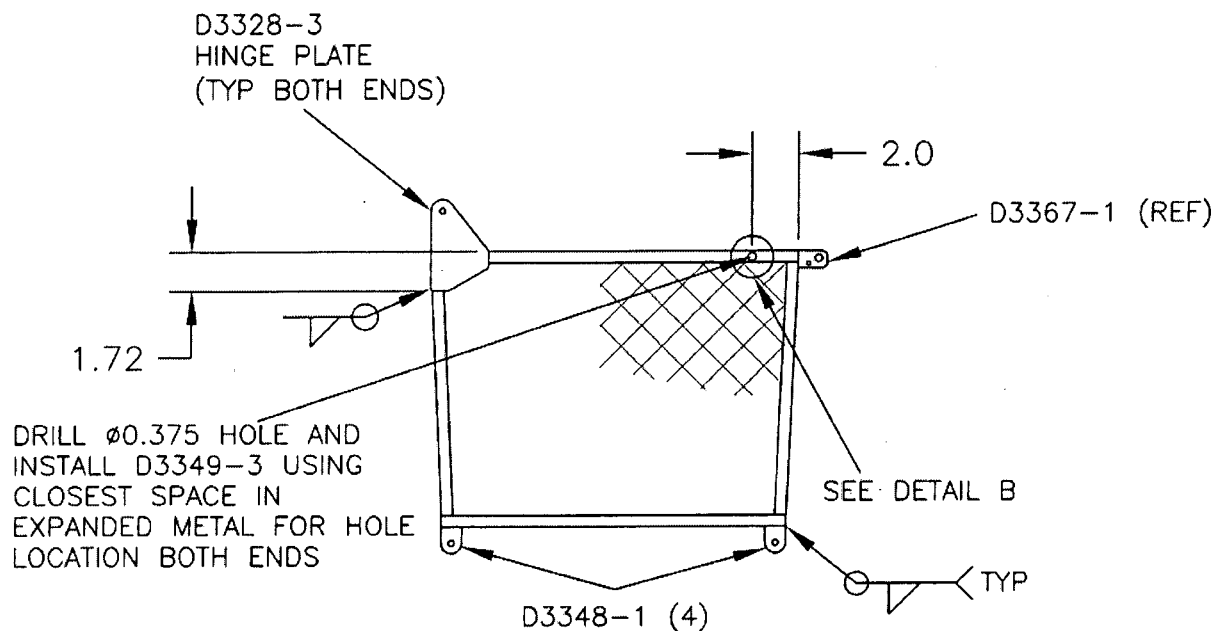
**D3324-041 BASKET BASE ASSEMBLY**

- 1) MESH MATERIAL: 1/2" - 18F GAUGE FLATTENED (0.040 THICK) EXPANDED CARBON STEEL (REF. DART SPEC. M569EX0.50-18F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 4.0 UNLESS OTHERWISE NOTED

**UNDER REVIEW**  
07.04.04  
NO. 316248  
WORK ORDER  
SUBJECT TO AMENDMENT  
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REVISIONS  
SHOWN TO  
REVISIONS  
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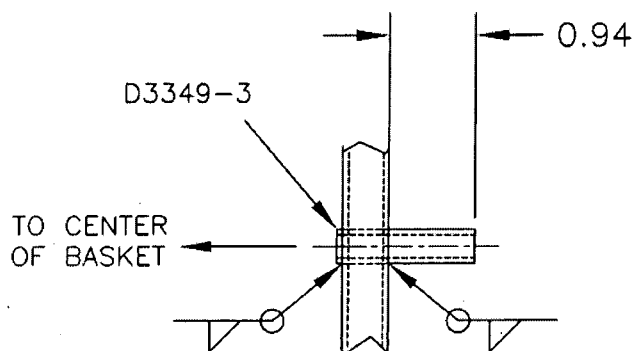


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DATE 05.03.04	TITLE BASKET BASE ASSEMBLY		SCALE 1:8

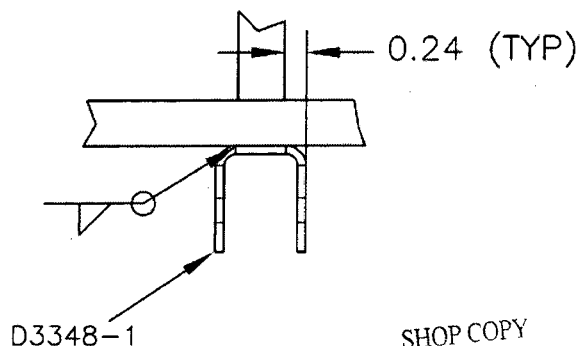


VIEW A-A

RELEASED  
05.03.05



DETAIL B  
(SCALE 1:2)



DETAIL C  
(SCALE 1:2)

UNDER REVIEW

05.07.05 PH

07-04-04  
PH

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